

Date: Monday, 28/04/2008 3:52:11 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 38852  
 Estimate Number : 10266  
 P.O. Number :  
 This Issue : 28/04/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 28/04/2008 Type : CROSSTUBES  
 Previous Run : 38729  
 Part Number : D350636013  
 Drawing Number : D2750 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 15/05/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.4.29  
 Comment : Est Rev:H 02.09.25 Rearranged procedure steps KJ  
 est rev I 06.03.30 Per rev. D dwg EC  
 Est Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM  
 Verified By:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD  
08.4/29



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 003

CHG 003

8 50866606

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

32463

① 14 8-5-2

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B37768

BB

08/05/02

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details).Drill using drill Jig DT8150 &amp; DT8864 .

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8864 and cut as per dwg D2750.

8-5-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:52:11 PM  
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Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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4-Drill pilot holes for Detail G using DT8330

5-Open up holes for detail B to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open holes for ground handling and detail E to 0.500" (8 holes per side)

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.297" \*\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\* Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297".

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Countersink Detail A as per dwg D2750.

10-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m106330* *08/05/02*

12-Grind welds flush as per Dwg D2750 *SL 8-5-2*

*W 8-5-2*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*SL 8-5-2 (4)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SL 8-5-2 (4)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*SL 8-5-5*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*SL 8-5-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 3:52:12 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
-----	-------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: 38753

SL 8-5-5

10.0	D34901	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: 233824

BE 08/05/12

11.0	D34905	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: 232597

BE 08/05/12

12.0	D2743	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: 237767

BE 08/05/12

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes section T-T 0.500" (4 per side) "size X" as per dwg D2750

2- Open holes section V-V 0.3125" (4 per side)

3-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

5-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: 107804

exp. date: 8-7-31

SL 8-5-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

6- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R Aluminum Rod batch: M107263 BE 08/05/12

7-Grind welds flush as per Dwg D2750

8-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

9-Deburr holes

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/05/12 (SL)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/12 (SL)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/06/03 (1)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

BL 08-06-04

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-06-04

(X)

19.0

ALS41032225

Insert



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

Insert

Batch: M1100489

HL

08-06-04

(X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Friday, 16/05/2008 11:35:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
1-Install inserts as per dwg D2750  
AND PER DSI9413 REV.A

MS 08-06-04 (X1)

21.0 D2745 Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
Bushing  
Batch: (X8) -> B36230

MS

22.0 D353525 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
WEARSHOE  
Batch: B38867

MS

23.0 D353625 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
GASKET  
Batch: B38565

MS

24.0 D35371 Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)  
WEARPAD  
Batch: B36426

MS

25.0 D37941 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Gasket

MS

26.0 D37931 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
Wearshoe

MS 08-06-04 (X1)

Date: Friday, 16/05/2008 11:35:39 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

B39276

JS

28.0	D37943	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B39361

JS

29.0	D37933	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

B39479

JS

30.0	D36721	Phenolic Washer
------	--------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Phenolic Washer

B39275

JS

31.0	AN526C1032R10	Screw
------	---------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M108062

JS

32.0	AN526C1032R18	Screw
------	---------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

M108079

JS

33.0	D36311	Washer
------	--------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch:

B38139

JS

34.0	D3488041	Blade Fitting Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch:

B38465

JS

08-06-04

(X)

Date: Friday, 16/05/2008 11:35:39 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	D3492041	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: (3x) 38562 (5x) 1338756 JH

36.0	D3492045	Plug Assembly
------	----------	---------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B334 35 JH

37.0	AN3C5A	Bolt
------	--------	------



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: M107862 JH

38.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M105300 JH

39.0	AN3C7A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: N/A ~~~~~ u/s 0806665

40.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M1107685 JH

41.0	AN8C35A	BOLT
------	---------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M106896 JH 08-06-04 XL

Date: Friday, 16/05/2008 11:35:39 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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42.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 38.0000 Each(s)/Unit Total: 46.0000 Each(s)

washer

Batch: M108077

jd

43.0	AN960C816L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M107520

jd

44.0	MS210436	NUT
------	----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M107736

jd

45.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M107939

jd

46.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M107394

jd

47.0	NAS1515H8L	WASHER
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: PIA mmm

aka Sootables

48.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: M106096

08-06-05

Date: Friday, 16/05/2008 11:35:39 AM  
User: Linda Lacelle

## Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M107804

EXP DATE: 08/10

4-Coat all exposed fasteners with "LPS Procyon" batch: M109251

08-06-05 (X)

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/06/05 (X)

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

51.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade

Batch: 36343

08/06/06 (X)

52.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107526

08/06/06 (X)

53.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107939

08/06/06 (X)

54.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107934

08/06/06 (X)

Date: Friday, 16/05/2008 11:35:39 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 38852

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

55.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M107551

AS 08/06/06 (X)

56.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: 3812 (38102)

AS 08/06/06 (X)

57.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/06/06 (X)

58.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013

Rev G 8/6/06

(X) 30

59.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10/09

Job Completion



C208106109

B38852

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV E

REF FAA STC: SR00646SE

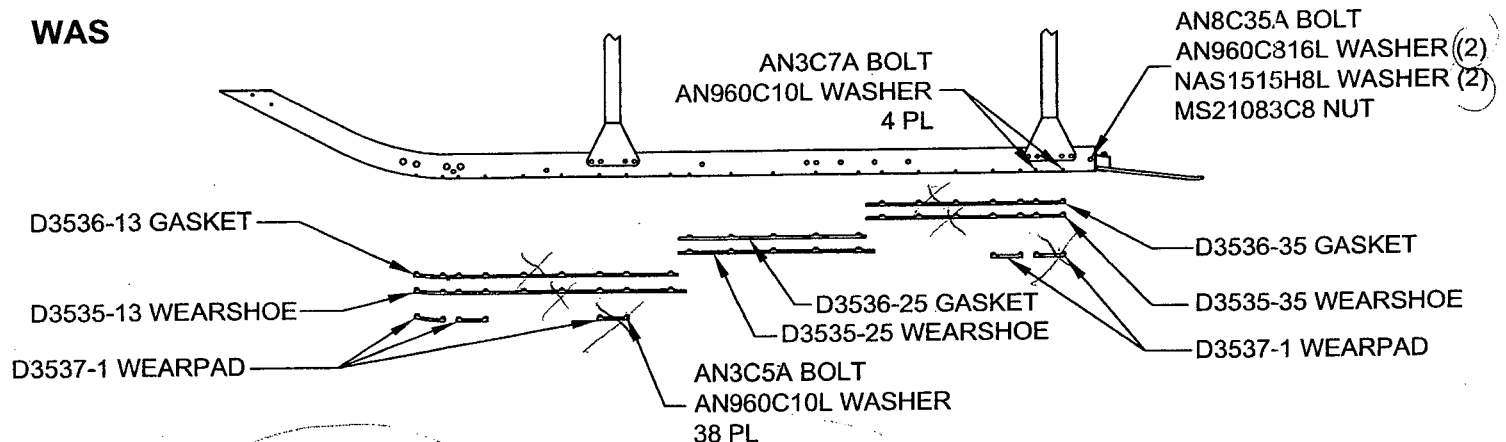
REF CANADIAN STC: SH99-7

FOR D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 004:

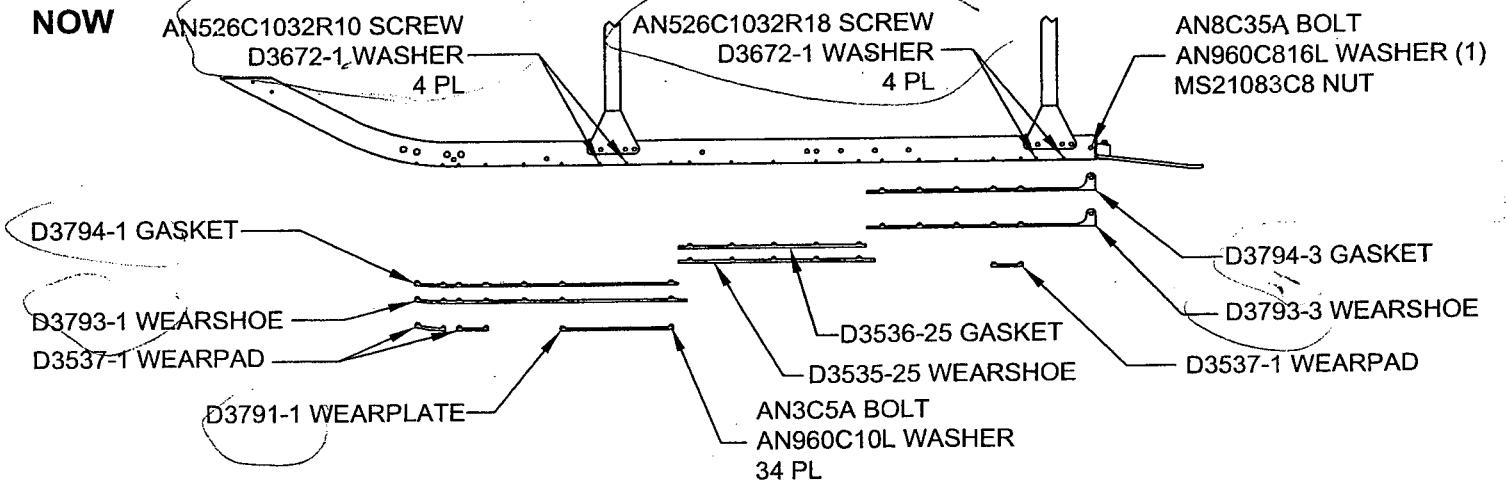
TO IMPROVE THE INSTALLATION OF THE DART D350-636-011/-012/-013/-014 SKIDTUBES ONTO THE CROSSTUBES, THE INSTALLATION AND PART NUMBERS OF THE FWD AND AFT WEARSHOES/GASKETS HAVE BEEN REVISED AS SHOWN IN FIGURE 1 BELOW.

FOR EXISTING CUSTOMERS THAT WOULD LIKE TO IMPROVE THE INSTALLATION OF THE SKIDTUBE TO THE CROSSTUBE, REFER TO PAGE 3 OF THIS DOCUMENT

**WAS**



**NOW**



**FIGURE 1 - D350-636-011/-012/-013/-014 AT CHG 004 AND INSTALLATION OF DSI 9413-011**  
(LOCATION OF AN526C1032RXX SCREWS ARE NOT TO BE USED TO MOUNT WEARSHOES)

**PRELIMINARY ISSUE**  
W/ 38852

A	NEW ISSUE	PH	08.05.14
REV.	DESCRIPTION		BY DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9413	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARSHOE INSTALLATION	NTS
DATE	08.05.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**DART****RELEASED**  
07-08-02

DESIGN <i>PH</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>TH</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 1 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
REV	DATE	DESCRIPTION	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3 / D2750-4; INCORPORATE D2738 AND D2740	
D	06.01.05	ADD HOLES AND SPACERS FOR APICAL FLOATS INCORPORATE DEO 9133 / 9157	
E	07.05.17	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY(38) NAS1515H3L; REMOVE QTY(10) NAS1515H8L; REMOVE D2741, QTY(2) AN960C816; REMOVE QTY(2) MS21083C8	

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-13	WEARSHOE
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3535-35	WEARSHOE
1	1	1	1	D3536-13	GASKET
1	1	1	1	D3536-25	GASKET
1	1	1	1	D3536-35	GASKET
5	5	5	5	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
42	42	42	42	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
38	38	38	38	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN3C7A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
46	46	46	46	AN960C10L	WASHER
2	2	2	2	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER
2	2	2	2	NAS1515H8L	WASHER

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D2750</b>	REV. E SHEET 2 OF 5
DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS

GENERAL NOTES:

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1. ALL DIMENSIONS ARE IN INCHES.
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS C-C, D-D AND F-F.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'F' SIZE HOLES ( $\emptyset 0.297$ ) FOR WEARSHOE INSERTS.
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3C5A/AN3C7A WEARSHOE BOLTS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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NO. 153

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 38843  
Part number: D350 636 011  
Description: 2nd tube 350  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

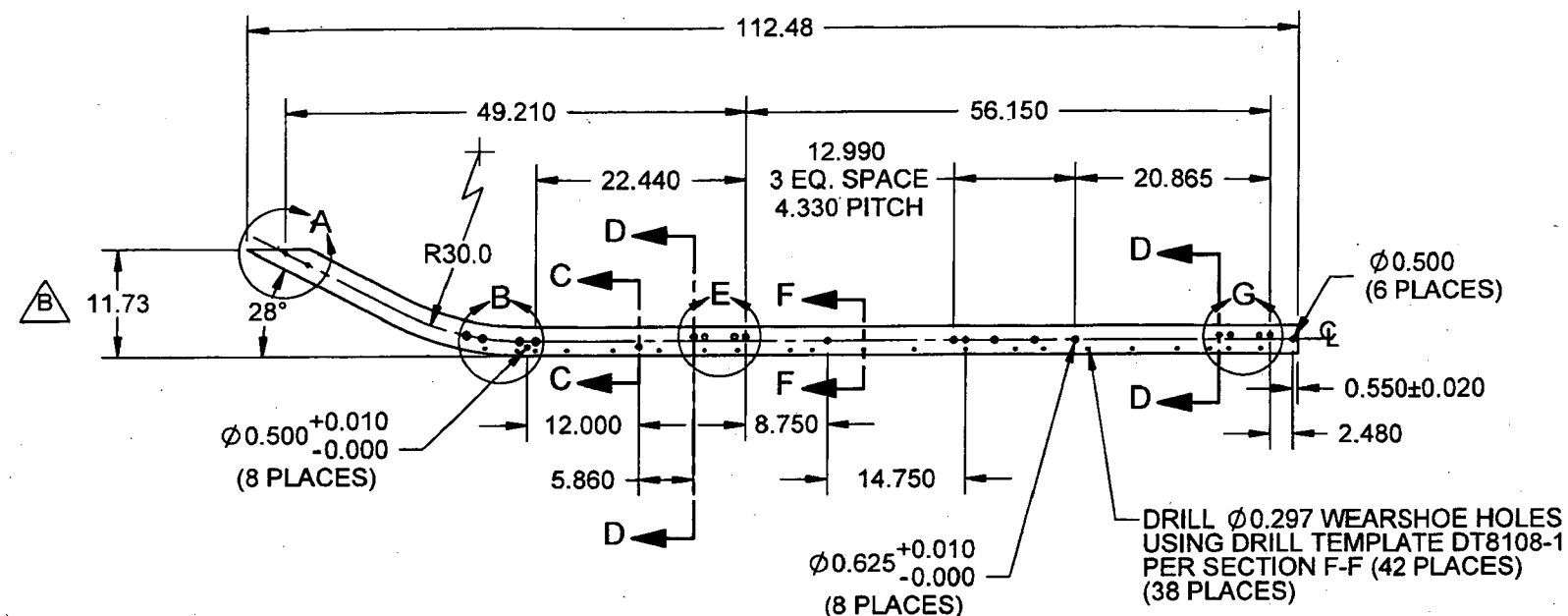
UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

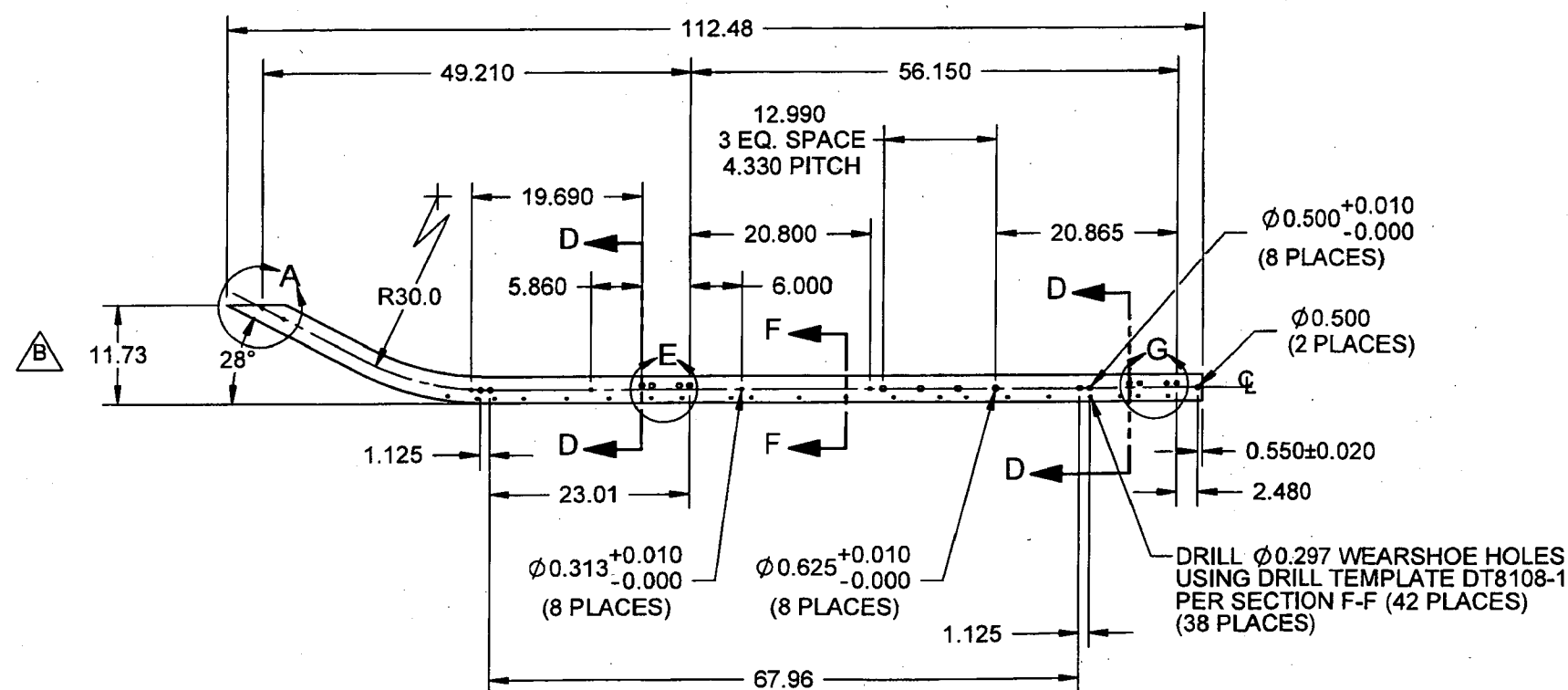
Qualifier Det. Dwyer Date of Test Coupon 08-05-07

Welder Det. Barclay Elliot Date of Test Coupon 08-05-07

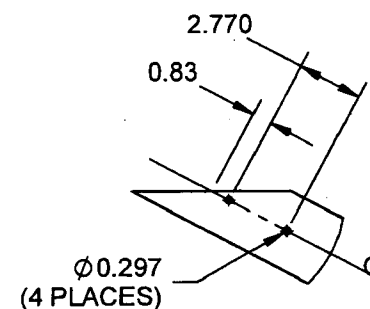
The above named individual is qualified in accordance with AWS D17.1.2001 to weld



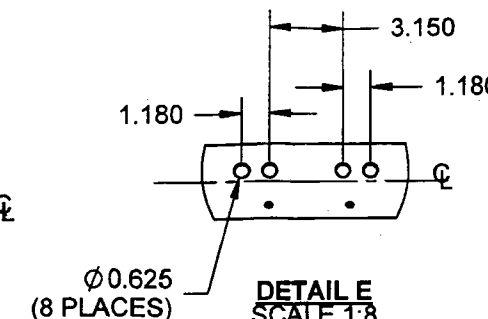
**D2750-1 LH SKIDTUBE (SHOWN)**  
**D2750-2 RH SKIDTUBE (OPPOSITE)**



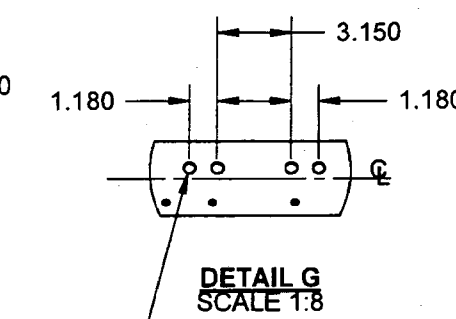
**D2750-3 LH SKIDTUBE (SHOWN)**  
**D2750-4 RH SKIDTUBE (OPPOSITE)**



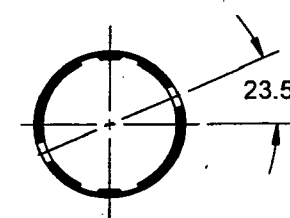
**DETAIL A**  
**SCALE 1:8**



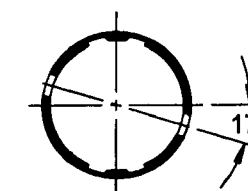
**DETAIL E**  
**SCALE 1:8**



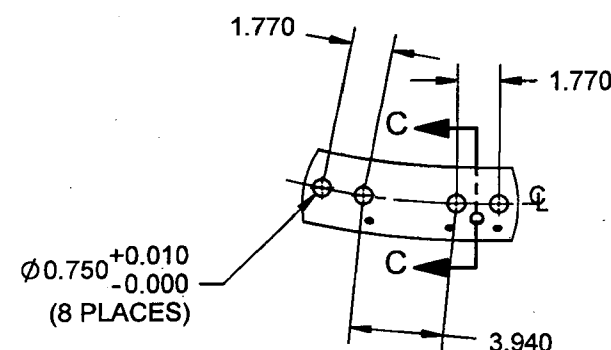
**DETAIL G**  
**SCALE 1:8**



**SECTION C-C**  
**SCALE 1:4**

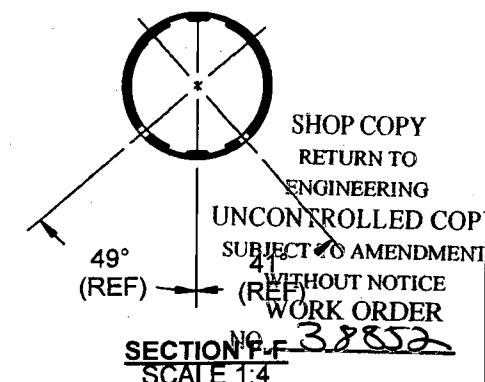


**SECTION D-D**  
**SCALE 1:4**



**DETAIL B**  
**SCALE 1:8**  
 (ALL DIMENSIONS ARE STRAIGHT LINE DIMENSIONS)

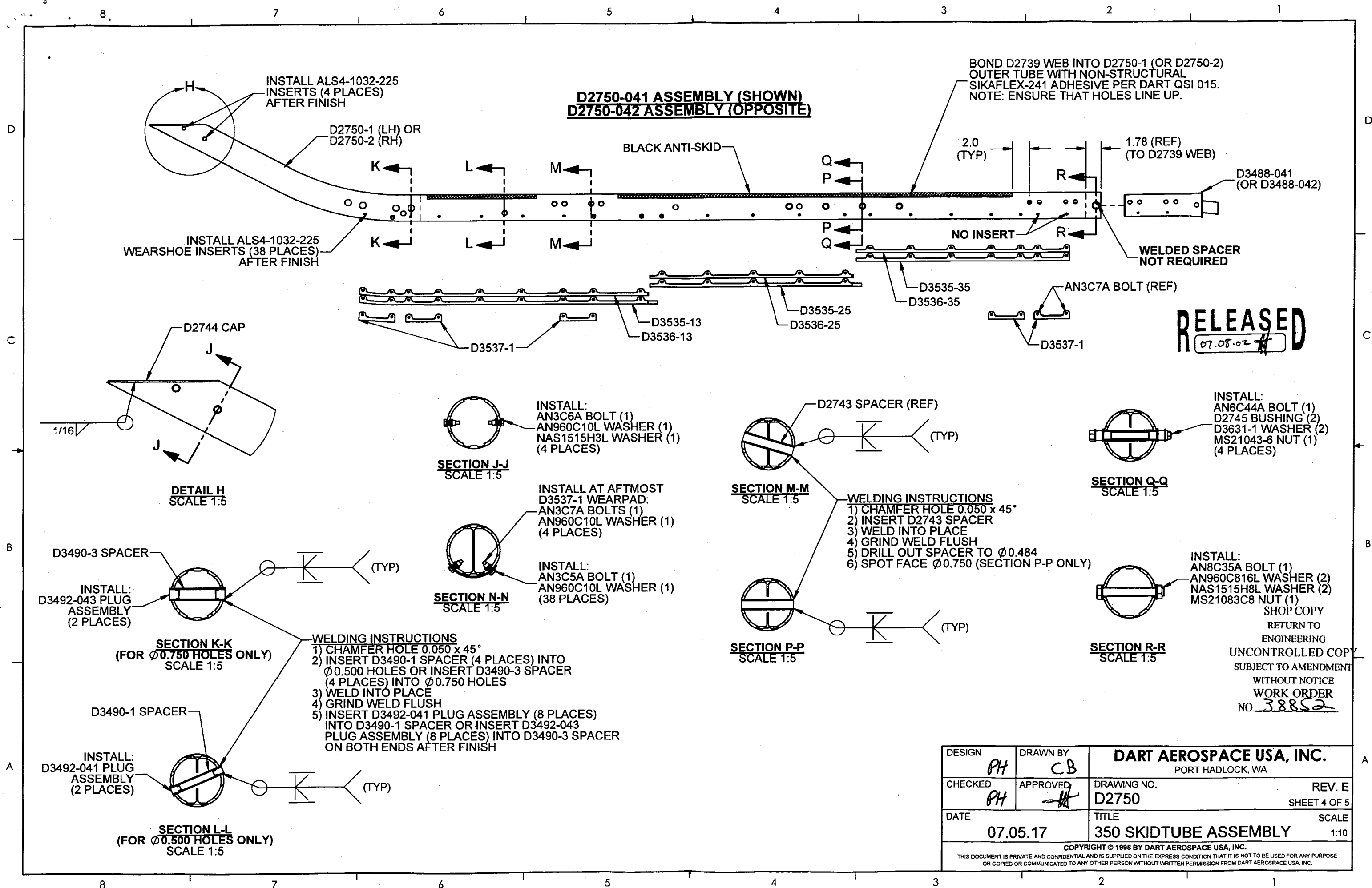
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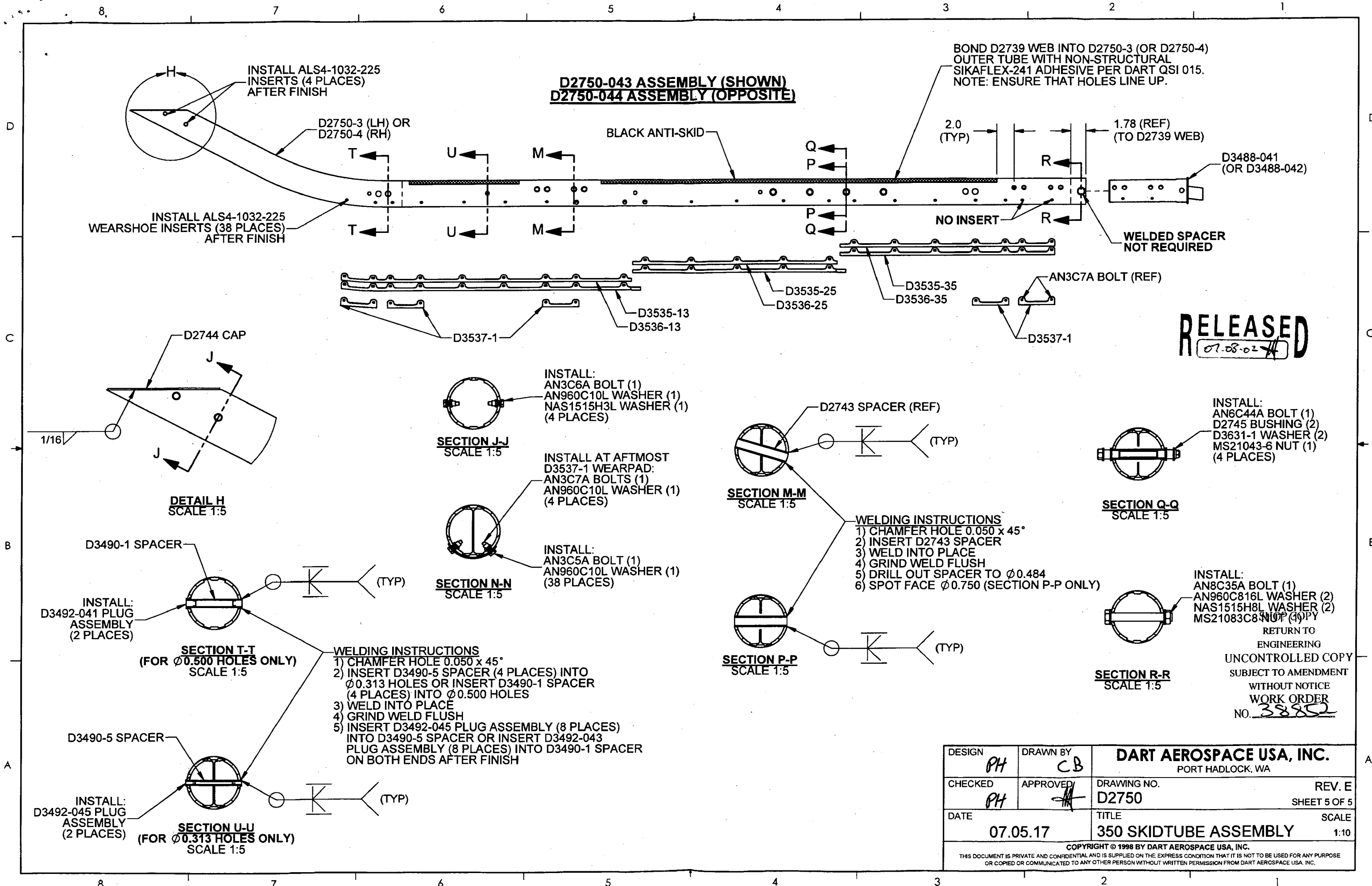


**SECTION F-F**  
**SCALE 1:4**

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DATE <b>07.05.17</b>		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE 1:20
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DATE	07.05.17			TITLE	SCALE
				350 SKIDTUBE ASSEMBLY	1:10
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